

Work Order ID 165538

Friday, August 25, 2017 2:27:37 PM

165538

Page 1

Item ID: D3914-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Long Basket Lid Assembly (350)
Start Date: 8/25/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 8/31/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: W **DAS 21 9-89** Date: AUG 25 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3914	D								
D4020	A								
100	Weld per dwg A/R S.S. rod Batch: <u>B13857</u>	0.00							
100	Large Fab								
	Memo	2.77							
	1- assemble ribs , weld as per dwg D3914 using DT9607A								
	2- weld hinge (3) and Mounting brackets as per dwg D3914								
	Visual inspect before welding mesh								
	3- tack weld mesh on basket as per dwg D3914								
	Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.00							
Quality Control									

1 SEP 06 2017**DAS 24 9-89**

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Customer:

Reference:

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.02

Quality Control

-Scribe Dart P/N and B/N as per dwg. Using 0.13 (minimum) high lettering per QSI 044 6.4

1 17-09-06 PD

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

130

Powdercoat

Memo

0.00

Powder Coating

1-Powder coat Black Sandtex (4.3.5.7) per Dart QSI 005 4.3

2-Mask this area prior to finish View E-E

3-Mask holes prior to finish Detail D

4-START TIME:

OVEN TEMPERATURE:

FINISH TIME:

M 136390.8:25
300°
8:551 φ 1709-7 DWG 34 9-09

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
135	QC3- Inspect Part Finish	0.00							
135									
QC	Memo	0.00							
Quality Control									
140	Wing Walk as per dwg QSI005 4.4 Batch <u>M1137945</u>	0.00							
140									
HandFinish	Memo	0.66							
Hand Finishing	1- Mask data plate and apply wing walk on outside surface of mesh as per dwg.								
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.01							
Quality Control									

DAS
15
9-89DAS
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Item ID: D3914-041 Accept ***N900040100*** Setup Start ***NS1***
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>wk</u>	0.00							
160									
Packaging	Memo	0.01							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.10							
Quality Control									

um

SEP 11 2017

DAS
21
9-89

Picklist Print

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Work Order ID: 165538

165538

Parent Item: D3914-041

D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 8/25/2017

Required Date: 8/31/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B
as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS
PER DWG REV.pc1 DD VERF:JLM IPP REV:D 13.06.21 DWG
REV.C DD VERF:JFS IPP Rev.E 17.06.12 As per Dwg.Rev.D DP
VerifyDD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3914-1

Manufactured

No

100

Each

8.0000

2

2

D3914-1

Rib

**** 165478 - D.M.L 2017-8-28**

Location

Loc Qty

Loc Code

WA004

8

165478

8

D3914-7

Manufactured

No

100

Each

14.0000

2

2

D3914-7

Rib

**** 165247 - D.M.L 2017-8-28**

Location

Loc Qty

Loc Code

WA004

14

165247

8

165474

6

D4018-5

Manufactured

No

100

Each

18.0000

9

9

D4018-5

Rib

**** 165248 D.M.L 2017-8-28**

Location

Loc Qty

Loc Code

WA004

18

165248

18

Picklist Print

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Work Order ID: 165538

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Parent Item: D3914-041

D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 8/25/2017

Required Date: 8/31/2017

Start Qty: 1.00

Required Qty: 1.00

D4035-043

Manufactured No

100

Each

6.0000

2 2

D4035-043

Lid Rib Assembly, Aft (350 Basket)

**** 164947 D.M.L 2017-8-28**

Location

Loc Qty

Loc Code

WA004

6

164946

6

D2581

Manufactured No

100

Each

62.0000

2 2

D2581

Mounting Bracket

**** 162923 D.M.L 2017-8-28**

Location

Loc Qty

Loc Code

WA004

62

161800

10

162923

22

163743

2

164446

28

D4016-3

Manufactured No

100

Each

40.0000

3 3

D4016-3

Hinge Half, Lid

**** 160518 D.M.L 2017-8-28**

Location

Loc Qty

Loc Code

WA004

40

159570

2

160518

38

D4020-5

Manufactured No

100

Each

2.0000

1 1

D4020-5

Mesh (350 Basket Long, Lid)

**** 164504 1708-30**

Location

Loc Qty

Loc Code

WA004

2

164841

2

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Shop Packet Print

Page 2

Picklist Print

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Parent Item: D3914-041

D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 8/25/2017

Required Date: 8/31/2017

Start Qty: 1.00

Required Qty: 1.00

D4021-3

Manufactured

No

100

Each

2.0000

1

1

D4021-3

Data Plate

160720 x 1 D.M.L 2017-8-28

Location

Loc Qty

Loc Code

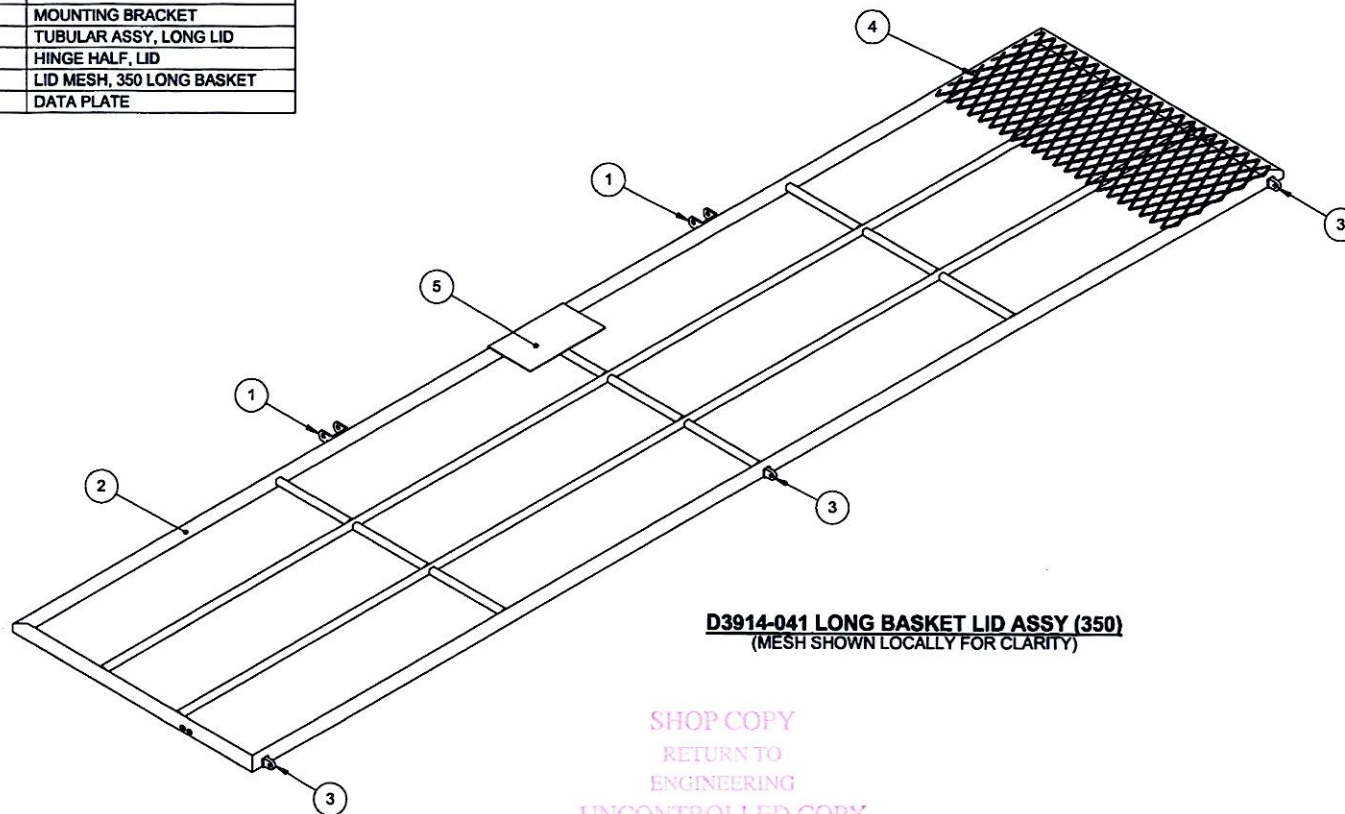
WA004

2

160720

2

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	2	D2581	MOUNTING BRACKET
2	1	D3914-101	TUBULAR ASSY, LONG LID
3	3	D4016-3	HINGE HALF, LID
4	1	D4020-5	LID MESH, 350 LONG BASKET
5	1	D4021-3	DATA PLATE



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
WITHOUT NOTICE
WORK ORDER
NO. 165538

WU AUG 25 2017

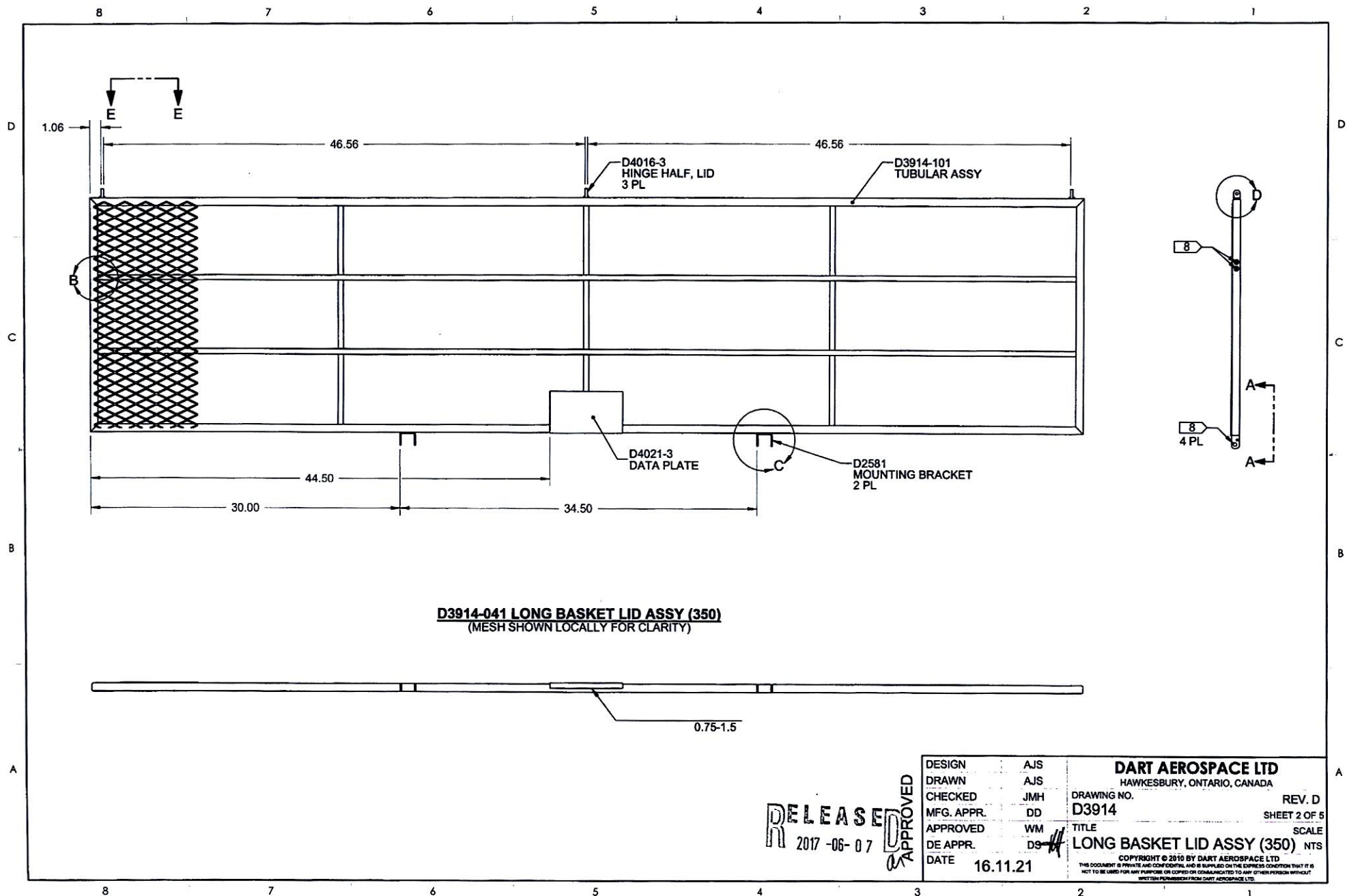
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SCRIBE DART P/N AND B/N USING 0.13 (MINIMUM) HIGH LETTERING PER QSI 044 6.4
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004
- 10) MASK THIS AREA PRIOR TO FINISH

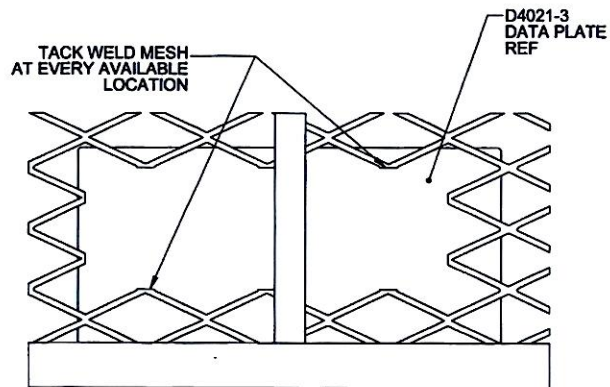
RELEASED
2017-06-07
EEN 17-580

D	SHEET 1: UPDATED NOTE 6 ADDED NOTE 10. D2728-3 DELETED. SHEET 2: SECTION AND VIEW LETTERS UPDATED. ADDED VIEW E-E. (PAR15-418)	AJS	16.11.21
C	REFER TO SHEET 3 D4035-041 DELETED AND REPLACED BY D4035-043. REASON: PROPARM NO LONGER OFFERED.	AJS	13.03.13
B	REMOVED D4086-210. UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JMH	DRAWING NO.	REV. D
MFG. APPR.	DD	D3914	SHEET 1 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	LONG BASKET LID ASSY (350)	NTS
DATE	16.11.21	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

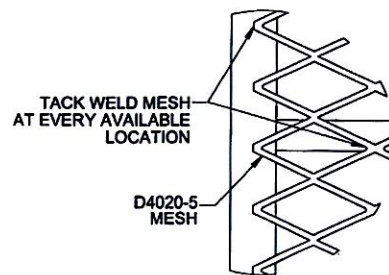
APPROVED



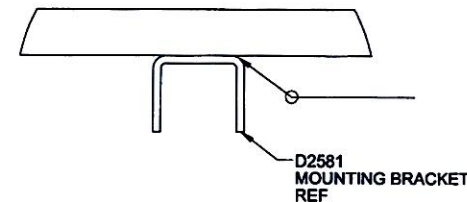
8 7 6 5 4 3 2 1



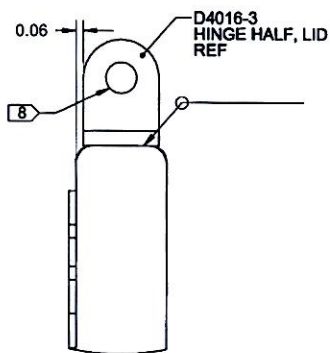
VIEW A-A
SCALE 4X



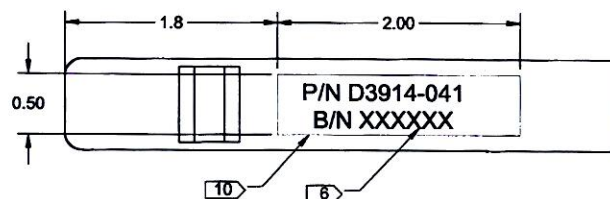
DETAIL B
SCALE 4X



DETAIL C
SCALE 4X
2 PL



DETAIL D
SCALE 8X
3 PL



VIEW E-E
SCALE 8X

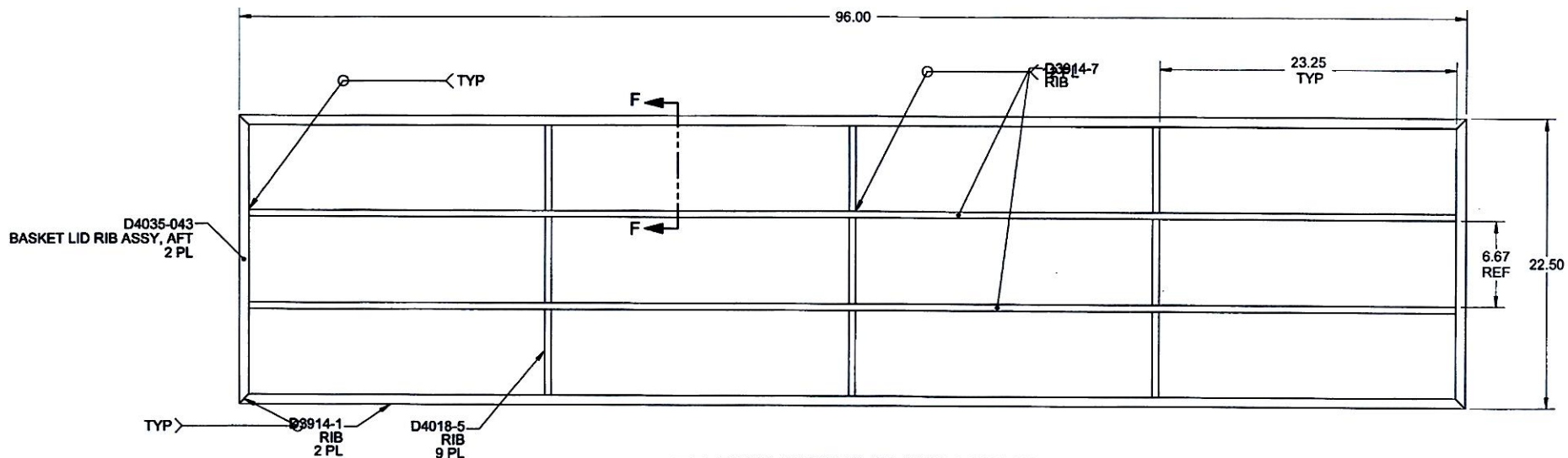
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2017-06-07

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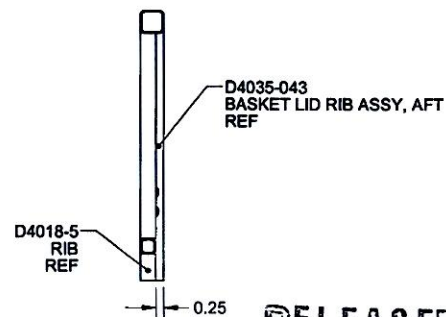
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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JMH	DRAWING NO.	REV. D
MFG. APPR.	DD	D3914	SHEET 3 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	LONG BASKET LID ASSY (350)	NTS
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8 7 6 5 4 3 2 1

ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	2	D4035-043	BASKET LID RIB ASSY, AFT



8 D3914-101 TUBULAR ASSY, LONG LID



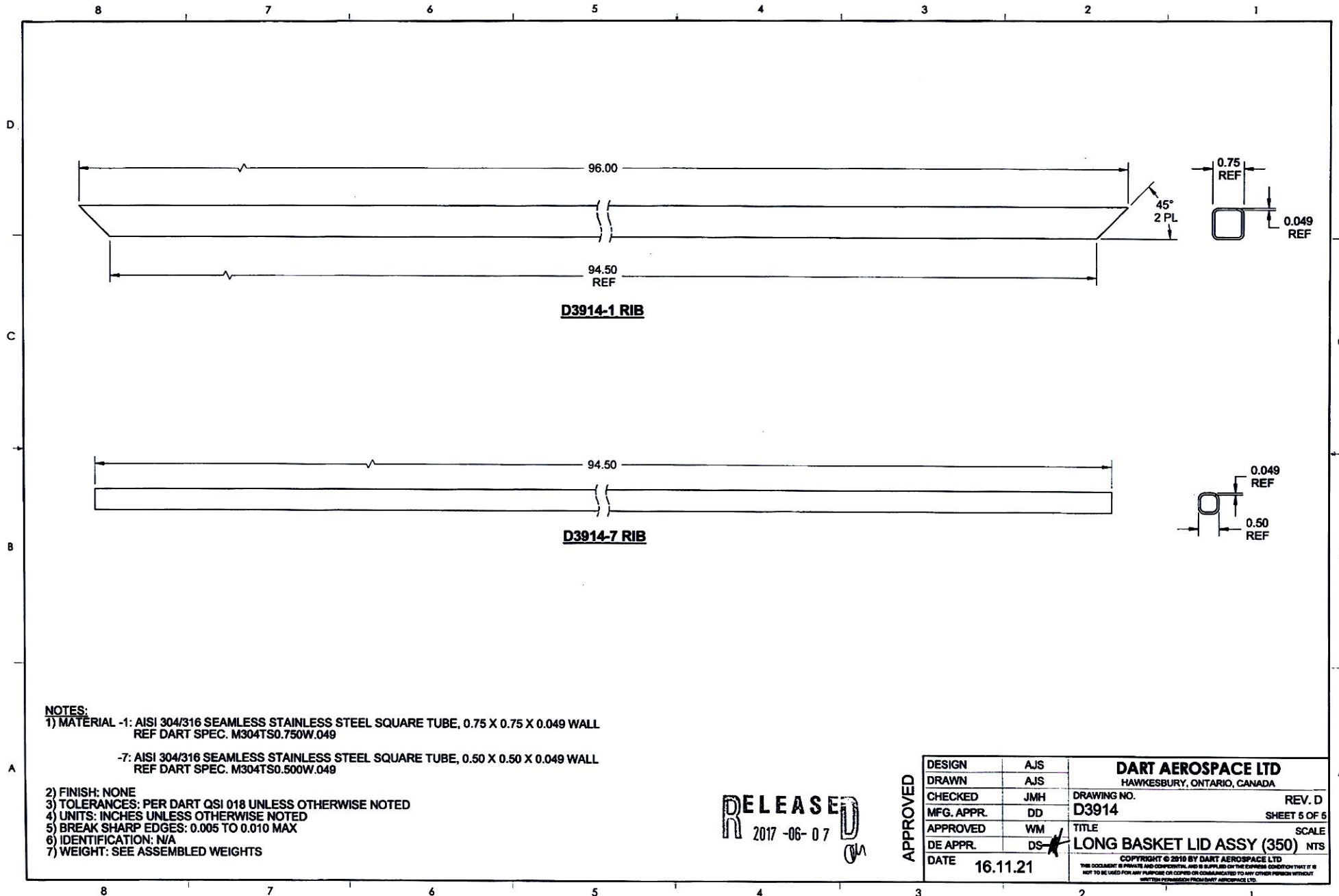
SECTION F-F
SCALE 2X

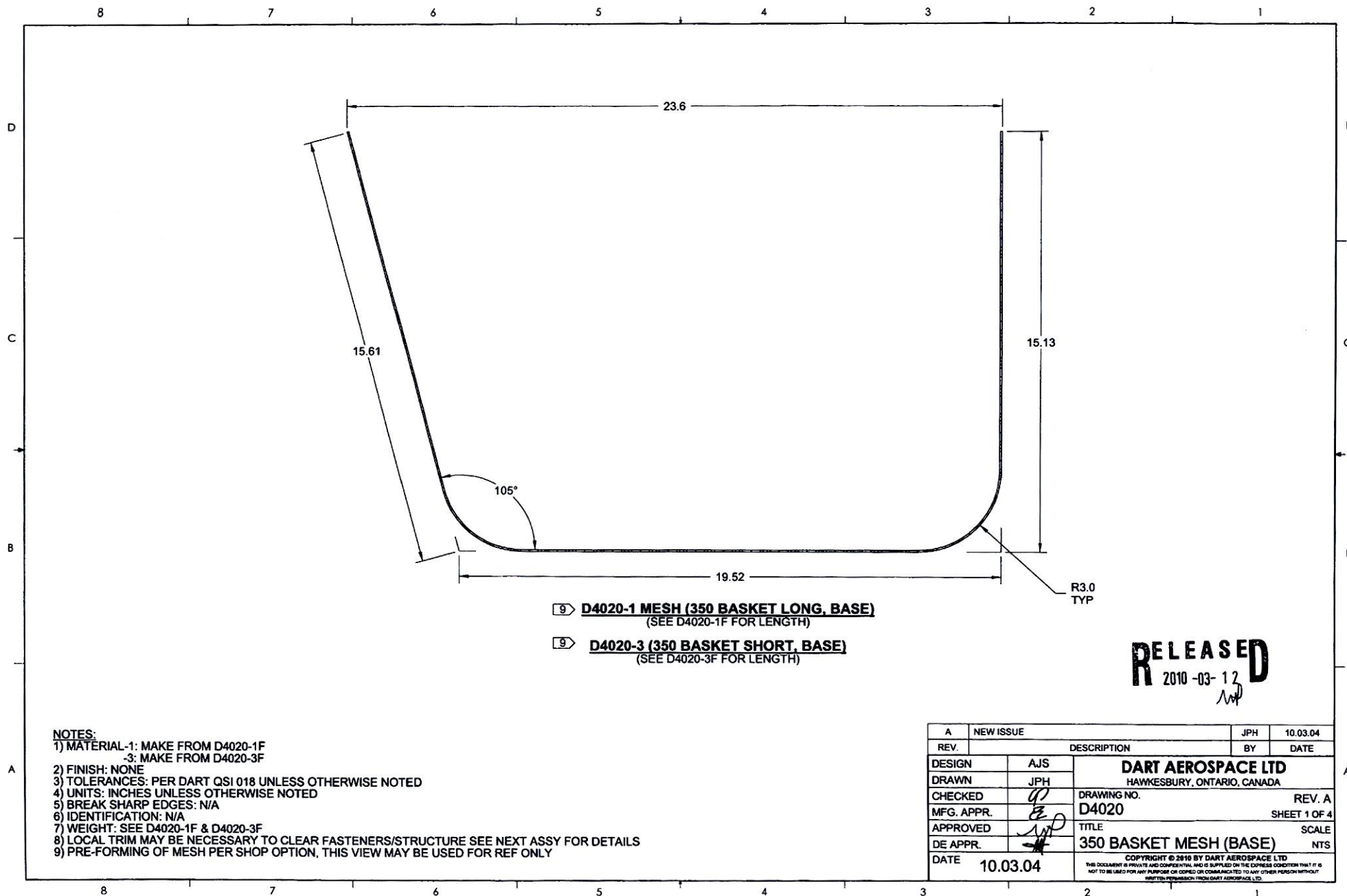
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 14.10 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS 0.06 FOR D3914-101
 - 9) WELD PER DART QSI 004

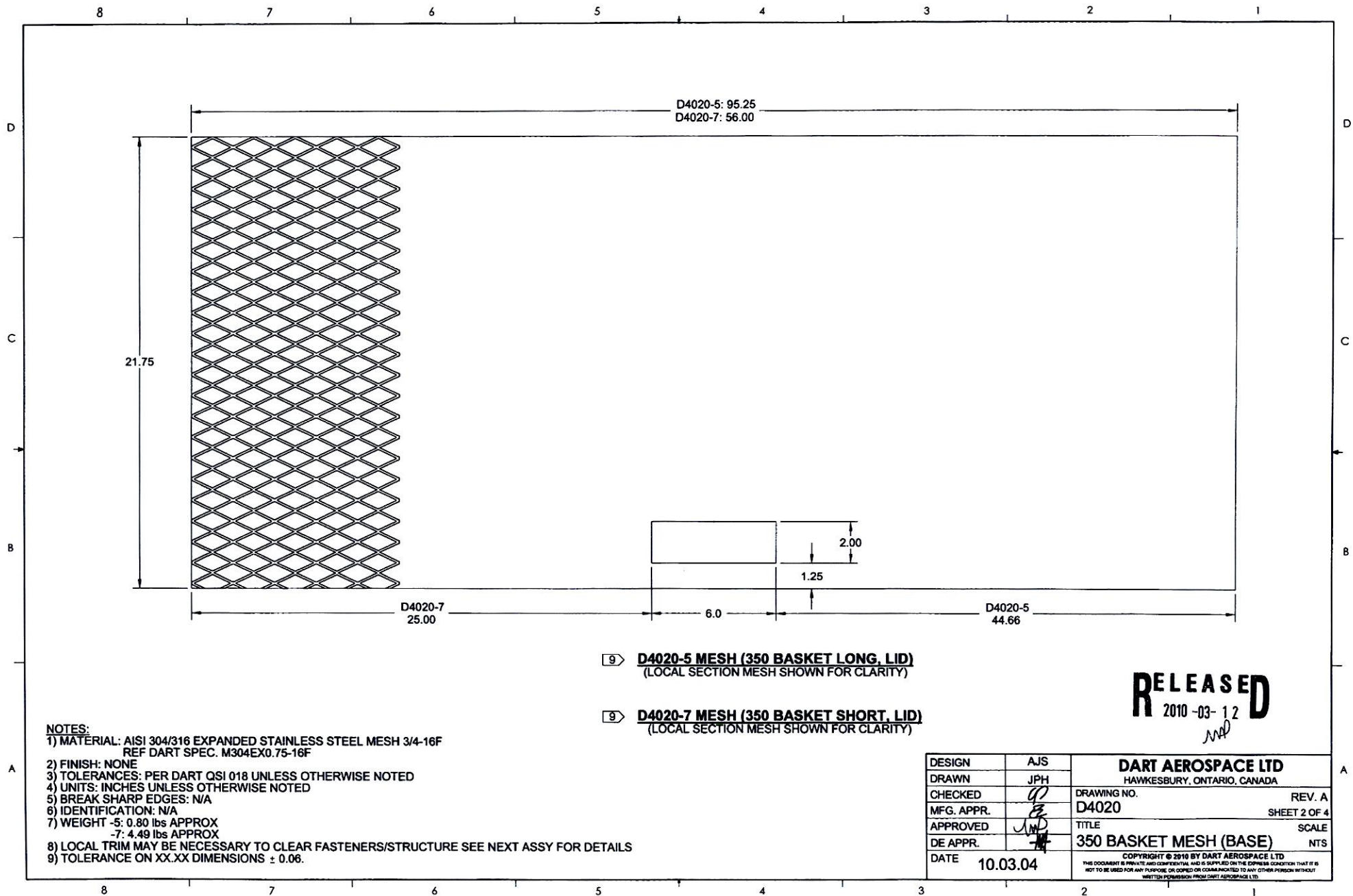
RELEASED
2017-06-07

APPROVED

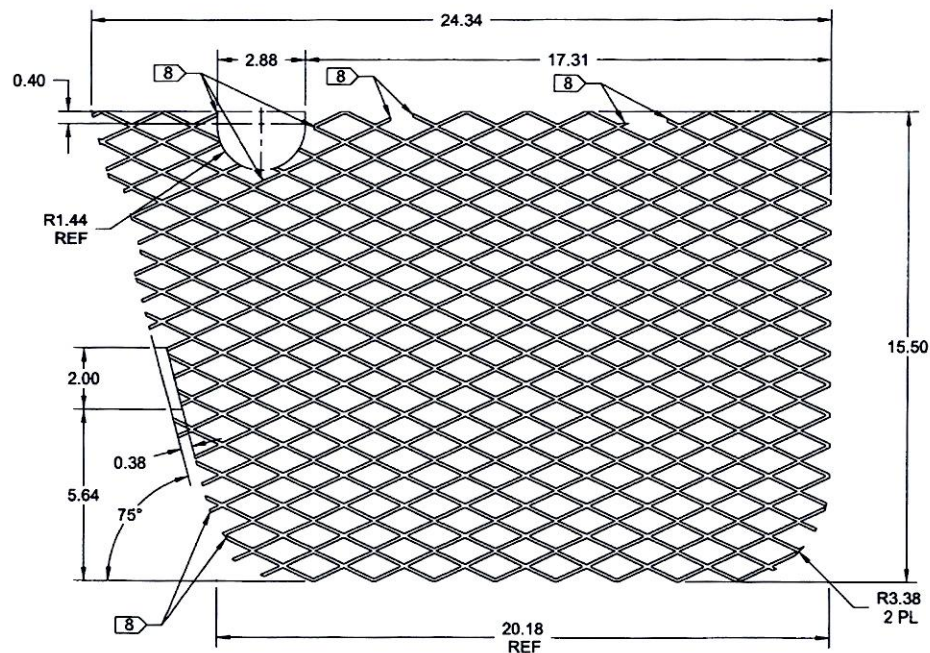
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JMH	DRAWING NO.	REV. D
MFG. APPR.	DD	D3914	SHEET 4 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	LONG BASKET LID ASSY (350)	NTS
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RELEASED
2010-03-12
MND



9 D4020-11 END MESH, BASKET

NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.22 lbs
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

RELEASED
2010-03-12
JMD

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4020	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 BASKET MESH (BASE)	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

